

Work Order ID 54804

December 22, 2009 1:25:02 PM

Page 1

Item ID: D3700-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Outboard Window Doubler

Start Date: 1/05/10 Start Qty: 4.00

Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 4.00

Customer:

Reference:

Run Start

Approvals:

Process Plan: CL

Date: 09/12/23 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3700	Rev B

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3700 □ Dwg Rev: B □ Prog Rev: B □ 12-

Deburr if necessary

6061 . 050

MAT NOT PULLED

B 10-1-7



110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B 10-1-7

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

⇒ 8.10.10.17



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54804

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Page 2

Item ID: D3700-3

Accept



Setup Start



Revision ID:

Item Name: Outboard Window Doubler

Stop



Start Date: 1/05/10 Start Qty: 4.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

BL 10-01-7

7

0

HandFinish

Memo

0.00

Hand Finishing

140

QC3- Inspect Part Finish

0.00

ll 10-01-7

17

0

QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location:

92

0.00

Packaging

Memo

0.00

Packaging

Per 10/01/09 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54804

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Page 3

Item ID: D3700-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Outboard Window Doubler

Start Date: 1/05/10 Start Qty: 4.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/11

BA/10-1-08
⑦

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 54804

Parent Item: D3700-3

Parent Item Name: Outboard Window Doubler



Comments:

Start Date: 1/05/10

Required Date: 1/15/10

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.050  6061-T6 .050 Sheet		Purchased	No				sf	110.5716	11.2400	20.		
											12-15-10	

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

110.5715

110791

34.5715

113216

74

17349

2

113189

113189

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 54804

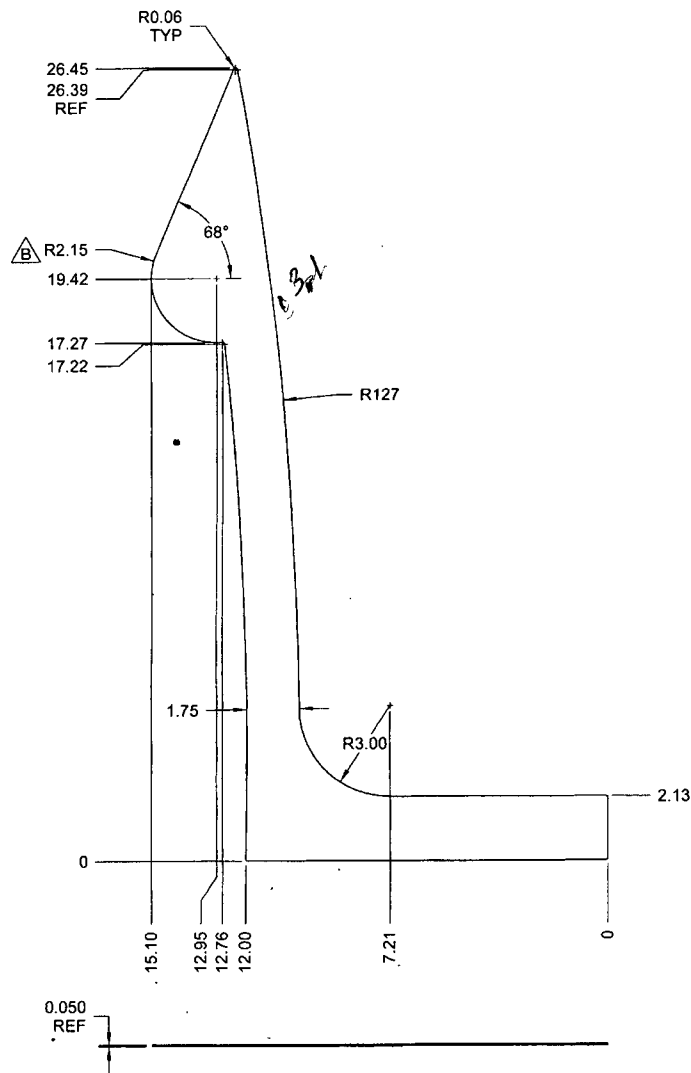
0209/12/23

D3700-1 INBOARD WINDOW DOUBLER

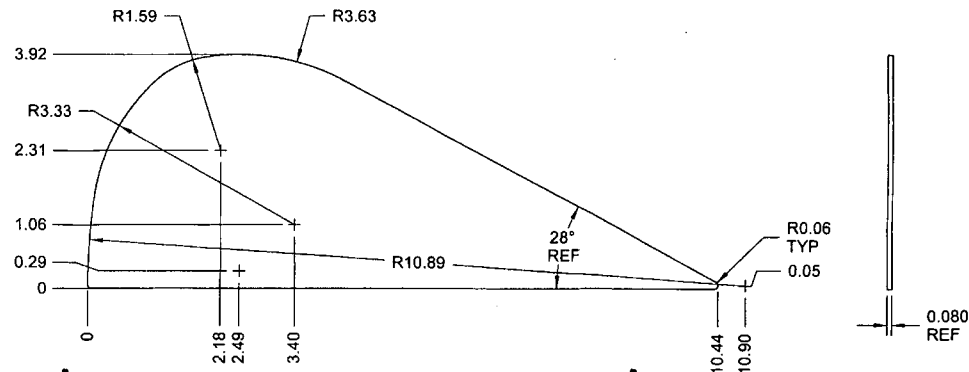
D3700-3 OUTBOARD WINDOW DOUBLER

RELEASED
09/24/23

B	ADDED 0.25" TO TOP PROFILE OF D3700-1 (ZN D8-2); REDIMENSION PARTS; REMOVED REFERENCES TO DXF FILES (NOTES 8 AND 9).		MB	09.03.18
A	NEW ISSUE		MB	08.01.29
REV.	DESCRIPTION		BY	DATE
DESIGN	DART AEROSPACE LTD			
DRAWN	HAWKESBURY, ONTARIO, CANADA			
CHECKED	DRAWING NO.		REV. B	
MFG. APPR.	D3700		SHEET 1 OF 2	
APPROVED	TITLE		SCALE	
DE APPR.	WINDOW DOUBLER		NTS	
DATE	09.03.18		<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D3700-3 OUTBOARD WINDOW DOUBLER



D3700-1 INBOARD WINDOW DOUBLER

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WORK ORDER
NO. 54804

RELEASED
09/04/09

NOTES:

- 1) MATERIAL:
D3700-1: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
D3700-3: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3700-X" USING FINE
POINT PERMANENT INK MARKER
- 7) WEIGHT: D3700-1 = 0.20 lbs
D3700-3 = 0.37 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3700	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WINDOW DOUBLER	NTS
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